

Work Order ID 166520

Tuesday, September 26, 2017 9:50:34 AM

166520

Just Today

Page 1

Item ID: D412-760-015

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Cabin Floor Protector

Stop *NS2*

Start Date: 9/26/2017 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/27/2017 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: DAS 21 9-89 Date: SEP 26 2017

Tooling: _____ Date: _____

Run Start *NR1*

QC: DAS 21 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-760	G								

100 Document Control 0.00
100
 DC DOCUMENT CONTROL
 Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D412-760-015 CHG002

DAS 27 9-89
 SEP 26 2017

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging

i SEP 26 2017 rd DAS 28 9-89 DAS 28 9-89

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.03
 Quality Control

DAS 27 9-89 DAS 27 9-89
 SEP 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 166520***166520***

Page 2

Tuesday, September 26, 2017 9:50:34 AM

Item ID: D412-760-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Floor Protector

Start Date: 9/26/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/27/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-760-015
Location:FG040DAS
28
9-89DAS
27
9-89

SEP 26 2017

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

DAS
21
9-89

SEP 27 2017

DAS
21
9-89

SEP 27 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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Picklist Print

Tuesday, September 26, 2017 9:50:42 AM

Page 1

Work Order ID: 166520

166520

Parent Item: D412-760-015

D412-760-015

Parent Item Name: Cabin Floor Protector

Start Date: 9/26/2017

Required Date: 9/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 07.07.05 new issue EC
IPP Rev:B 08-08-20 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3574-5 *D3574-5* Cabin Floor Protector DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	1			
									**	166533			DAS 28 9-89
D3574-6 *D3574-6* Cabin Floor Protector DAS 27 9-89		Manufactured	No			110	Each	1.0000	1	1			
									**				DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				PKG			1						
					166403		1			166520			
D3575-5 *D3575-5* Cargo Floor Protector DAS 27 9-89		Manufactured	No			110	Each	1.0000	1	1			
									**	166524			DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				PKG			1						
					166404		1						
D3575-6 *D3575-6* Cargo Floor Protector DAS 27 9-89		Manufactured	No			110	Each	1.0000	1	1			
									**				DAS 28 9-89
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				PKG			1						
					166405		1			166521			

SEP 26 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, September 26, 2017 9:50:42 AM

Page 2

Work Order ID: 166520
 Parent Item: D412-760-015
 Parent Item Name: Cabin Floor Protector

166520
D412-760-015

Start Date: 9/26/2017 Required Date: 9/27/2017
 Start Qty: 1.00 Required Qty: 1.00

D3580-1

Manufactured No

110 Each

20.0000

6 6

D3580-1

Joggle Bracket

**

SEP 26 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST040

20

163915

12

164724

8

D3628-1

Manufactured No

110 Each

371.0000

14 14

D3628-1

Washer, Cupped

**

SEP 26 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

83587

10

ST044

111

151898

111

ST051A

250

164007

250

D3628-3

Manufactured No

110 Each

56.0000

6 6

D3628-3

Cupped Washer

**

SEP 26 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST043

56

148674

56

MS24694-S100

Purchased No

110 Each

84.0000

6 6

MS24694-S100

Flat Head Screw

**

SEP 26 2017

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST283

84

m135864

1

m138045

83

Tuesday, September 26, 2017 9:50:42 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Tuesday, September 26, 2017 9:50:42 AM

Page 3

Work Order ID: 166520

166520

Parent Item: D412-760-015

D412-760-015

Parent Item Name: Cabin Floor Protector

Start Date: 9/26/2017

Required Date: 9/27/2017

Start Qty: 1.00

Required Qty: 1.00

MS24694-S54

Purchased

No

110

Each

52.0000

14

14

MS24694-S54

SCREW

**

SEP 26 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

ST284

52

m138237

52

14

NAS1149D0363J

Purchased

No

110

Each

993.0000

28

28

NAS1149D0363.I

Washer

**

SEP 26 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

384

m137963

384

ST263

609

m138336

609

28

NAS1149D0463J

Purchased

No

110

Each

1,317.000

12

12

NAS1149D0463.I

Washer

**

SEP 26 2017

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

445

M135056

40

M137699

405

Return2017

16

M136665

16

ST263

856

M137988

600

M138084

24

M138230

232

12

166520

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 9/26/2017 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/27/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D412-760	G
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100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-760-015 CHG002

DAS
21
9-89

~~SEP 7 6 2017~~

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.03

Quality Control

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Part Number	Description
X					D412-760-011	CABIN FLOOR PROTECTOR KIT
	X				D412-760-013	CABIN FLOOR PROTECTOR KIT
		X			D412-760-015	CABIN FLOOR PROTECTOR KIT
			X		D412-760-017	CABIN FLOOR PROTECTOR KIT
				X	D412-760-019	CABIN FLOOR PROTECTOR KIT
1					D3574-1	CABIN FLOOR PROTECTOR
1					D3574-2	CABIN FLOOR PROTECTOR
	1				D3574-3	CABIN FLOOR PROTECTOR
	1				D3574-4	CABIN FLOOR PROTECTOR
		1			D3574-5	CABIN FLOOR PROTECTOR
		1			D3574-6	CABIN FLOOR PROTECTOR
1					D3575-1	CABIN FLOOR PROTECTOR
1					D3575-2	CABIN FLOOR PROTECTOR
	1				D3575-3	CABIN FLOOR PROTECTOR
	1				D3575-4	CABIN FLOOR PROTECTOR
		1			D3575-5	CABIN FLOOR PROTECTOR
		1			D3575-6	CABIN FLOOR PROTECTOR
6	4	6	6	6	D3580-1	JOGGLE BRACKET
			1		D3788-1	CABIN FLOOR PROTECTOR
			1		D3788-2	CABIN FLOOR PROTECTOR
			1		D3788-3	CABIN FLOOR PROTECTOR
			1		D3788-4	CABIN FLOOR PROTECTOR
14	40	14	14	10	D3628-1	CUPPED WASHER
6	8	6	6		D3628-3	CUPPED WASHER
				1	D4122-1	FLOOR PROTECTOR, FORWARD
				1	D4122-3	FLOOR PROTECTOR, AFT
28		28	28		NAS1149D0363J	WASHER (AN960JD10)
12		12	12		NAS1149D0463J	WASHER (AN960JD416)
14		14	14		MS24694S54	SCREW
6		6	6		MS24694S100	SCREW